MUST SHIP TUDAY.

	110
Work Order ID 59356 - 2	Solit
Wednesday, June 02, 2010 11:37:48 AM	11-



Page 1

Item ID: Revision ID:	D4127-1		Accept				s	Setup Star	1100111011	
	6/2/2010 Start Qty: 4.00 6/2/2010 Req'd Qty: 4.00	5-		Cust Item I Customer:	D:			360	P	
Approvals:	Process Plan: MP	Date: 0-6-2	Tooling: SPC (Y/N):		ate:		F	tun Star Sto		
Sequence ID/ Work Center II	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr									
D4127	A									
100 Waterjet	Memo		0.00				BIO	-6-2		
FLOW CNC Waterje	Cut as per DWG REV PROG RE	(<u>A</u>							6)
110	QC2- Inspect parts off	machine FAI/FAIB	0.00				150	0-6-3		
QC Ouality Control	Memo		0.00				PRI	ارسو <u>-</u>		

Dart Aerospace

W/O:			V	VORK ORDER CH	IANGES					
DATE	STEP	PROC	EDURE CH	IANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Ca	tegory:	NCI	R: Yes	No DQ	A:	Date:	
	R	esolution:	Disposit	ion:	QA:	N/C CI	sed:		_ Date: _	
NCR:		We	ORK OR	DER NON-CONF	ORMANCE	(NCR)			
DATE STEP		Description of NC		Corrective Action	Section B		Verific	cation	Approval	Approval
DAIL	SILF	Section A	Initial Chief Eng	Action Descri Chief Eng	ption	Sign & Date		ion C	Chief Eng	QC Inspector
		1								

Work Order ID 59356

Wednesday, June 02, 2010 11:37:48 AM



Page 2

Item ID:

D4127-1

Accept

Setup Start

Stop



Revision ID:

Start Date:

Item Name: Lug

Required Date: 6/2/2010

6/2/2010

Start Oty: 4.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

0.00

Date:

Run



QC:

Date:

SPC (Y/N):

Date:

Stop

Start

Sequence ID/

Work Center ID

Operation Description Set Up/ Run Hours Tool ID

Tool # Plan Code

Accept Qty

Reject Reject Qty Number

Insp. Stamp

130

Mill Conv Conventional Milling Machine Memo

MILL RADS, DRILL HOLES AS PER DWG GRIND RAD .060"-.100" BY HAND



140

QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

Memo

SN 10/06/02



150

Memo

OC8- Inspect parts - second check

0.00

0.00 Suffice 02

Quality Control

Dart Aerospace Ltd	Dart	Aeros	pace	Ltd
--------------------	------	-------	------	-----

W/O:			W	ORK ORDER CH	ANGES					*
DATE	STEP	PRO	CEDURE CH		ANGEO	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No		PAR #:		egory:						
	Re	solution:							_ Date: _	
NCR:		V	VORK ORE	DER NON-CONFO	DRMANCE	(NCR)			
		Description of NC		Corrective Action Se			Verific	cation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Descri Chief Eng	ption	Sign & Date		on C	Chief Eng	QC Inspector
									5	

Page 3

Wednesday, June 02, 2010 11:37:48 AM

Item ID:

D4127-1

Accept

Setup Start

Stop



Revision ID:

Start Date:

Item Name: Lug

6/2/2010

Start Qty: 4.00 Reg'd Oty: 4.00

Cust Item ID:

Customer:

Reference:

Approvals:

Required Date: 6/2/2010

Process Plan:

Date:

Tooling:

Date:

Start Run



QC:

Date:

SPC (Y/N):

Set Up/

Date:

Stop

Sequence ID/ Work Center ID

160

HandFinish

Hand Finishing

Operation Description

Chemical Conversion Coat per QSI005 4.1

Memo

Run Hours 0.00

0.00

Tool ID

Tool# Plan Code Accept Qty

Reject Qty

Reject Insp. Number Stamp

10/06/03

170

Powdercoat

Powder Coating

574at: 2:30p- 0.00 Temp: 3200f Find 3:00p-

10/06/03 5 0

180

Quality Control

QC3-Inspect Part Finish

0.00

Memo

0.00

5 H10.6-3.

Dart Aerosp	ace L	_td
-------------	-------	-----

W/O:			W	ORK ORDER CH	ANGES					
DATE	STEP	PRO	OCEDURE CHA	NGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Cate	gory:	NC NC	R: Yes	No DQ	A:	_ Date: _	
	R	esolution:	Dispositio	on:	QA	: N/C Cld	sed:		Date:	
NCR:			WORK ORD	ER NON-CONF	ORMANCE	(NCR)			
DATE STEP		Description of NC				Section B Verificati			n Approval	Approval
	5	Section A	Initial Chief Eng	Action Descri Chief Eng	ption	Sign & Date	Section		Chief Eng	QC Inspector
-			= 5 - 8)k:				
		x .			4					
					4)					

Work Order ID 59356

Wednesday, June 02, 2010 11:37:48 AM



Page 4

Item ID:

D4127-1

Accept



Setup Start

Stop



Revision ID:

Start Date:

Item Name: Lug

Required Date: 6/2/2010

6/2/2010

Start Oty: 4.00

Reg'd Oty: 4.00

Cust Item ID:

Customer:

Tool ID

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Start Run



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/ Work Center ID

210

Packaging

Packaging

Operation Description

Identify as per dwg & Stock Location:

Set Up/ Run Hours

0.00

0.00 =7 m. A 10/06/04

Tool#

Plan

Code

Qty

Reject Accept

Qty

Reject Number

Insp. Stamp

220

QC21- Final Inspection - Work Order Release

0.00

QC

Quality Control

Memo

Memo

0.00

10/06/04 Af

Dart Aerosp	pace Ltd
-------------	----------

W/O:			W	ORK ORDER CH	HANGES					
DATE	STEP	PRO	CEDURE CH	ANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
										1,27
Part No	:	PAR #:	Fault Cat	egory:	NC	R: Yes	No DQ	A:	Date: _	
	R	esolution:	Dispositi	on:	QA	: N/C CI	osed:		Date:	-
NCR:		V	VORK OR	DER NON-CONF	ORMANCE	(NCR)			
DATE OTEN		Description of NC	Description of NC Corrective Action			Section B Verifi			Approval	Approval
DATE STEP	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Secti		Chief Eng	QC Inspector	
										11
		li .								
	1		1			I	1			

Picklist Print

Wednesday, June 02, 2010 11:37:48 AM

Work Order ID: 59356

Parent Item:

D4127-1

Parent Item Name: Lug

Comments:



IPP REV:A NEW ISSUE 10-05-28 JLM VERIFIED BY:EC

Start Date: 6/2/2010

Required Date: 6/2/2010

Page 1

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status	
M6061T6B0.750X06.00		Purchased	No				f	44.0800	0.35	1.473684	2.			

6061T6 BAR .750 X 6.00

HB 10-6-3

Location Loc Qty Loc Code MAT03 44.08 112567 44.08

112567

Dart	Aeros	pace	Ltd
------	-------	------	-----

W/O:		WORK ORDER CHANGES									
DATE	STEP	PRO	CEDURE CH	ANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
							50 = 150				
Part No:		PAR #:	Fault Cat	egory:	N	CR: Yes	No DQ	A:	_ Date: _		
Resolution:		esolution:	Dispositi	on:	Q	A: N/C Closed: Date:					
NCR: WORK ORDER NON-CONFORMANC					E (NCF	R)					
DATE	CTED	Description of NC	Corrective Action		Section B		Verific	cation	Approval	Approval	
DATE	STEP	Section A	Initial Chief Eng	Action Descri Chief Eng		Sign 8 Date		on C	Chief Eng	QC Inspector	
NOTE: D											

DART AEROSPACE LTD	Work Order:	59356
Description: D4127-1 Luc	Part Number:	D4127-1
Inspection Dwg: 74()7-(Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.47	4030	4,449	+			
-306	400	1308	4	*		
.750	7010	740	1			
126	4010	139	*	-		
.735	4/- ,010	,739	×			
3.700	=,010	3.100				
- /	±.030		/			
3.06 0.257 7.375	±.030	3.060				
7.375	+.010	R. 375		1		
				1		
			-			
		1	-			
		-				
				-		
						*,

<u> </u>				
Measured by:	12/5/	Audited by:	Prototype Approval:	N/A
Date:	10-1-7	Date: 10 00-07	Date:	N/A
Ducc.	10 0 0	10.000		

Rev	Date	Change	Revised by	Approved
Kev	Date	Ollarige	KJ/JLM	
A		New Issue	KOJOCIAI	

¥ 59356

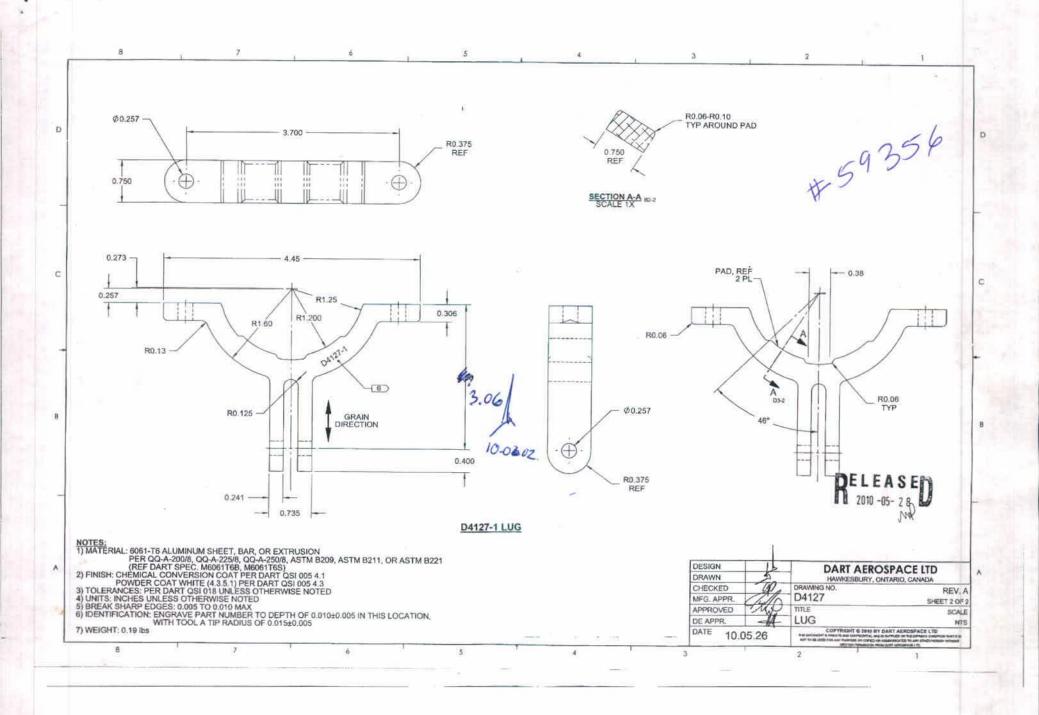
D4127-1 LUG

RELEASED

A	NEW ISSUE		мв	10.05.26
REV.		DESCRIPTION	BY	DATE
DESIG	N I	DART AF	ROSPACEL	TD
DRAW	N T		Y, ONTARIO, CANA	
CHECK	CED 4	DRAWING NO.		REV. A
MFG. A	PPR.	D4127		SHEET 1 OF 2
APPRO	VED A	TITLE		SCALE
DE AP	PR.	LUG		NTS
DATE	10.05.26	Heli immunent a Peninty and Consequent and to be used row our rupping on our	O BY DART ALROSPACE A. MO E SOFT, GO OF THE SOFT TO THE SHEET SOFT TO MOST STORY	LTD supprovings to a corposion without

Dart Aeros	pace Ltd
------------	----------

W/O:			WC	ORK ORDER CH	IANGES						
DATE STEP		PRO		Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector				
									¥		
Part No:		PAR #:	Fault Cate	gory:	NCR: Yes No DQA:				Date:		
Resolution:		esolution:	Disposition	n:	QA	QA: N/C Closed:					
NCR:		1	WORK ORDI	ER NON-CONF	ORMANCI	(NCR)				
DATE	STEP	Description of NC	Description of NC Corrective Actio					ation	Approval	Approval	
DAIL	JILI	Section A	Initial Chief Eng	Action Descri Chief Eng	ption	Sign & Date	Secti		Chief Eng	QC Inspector	
*	29										
									79		



Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES									
DATE	STEP	PRO	OCEDURE CHA	NGE		Ву	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
		=									
	-								t.		
Part No: PAR #:		Fault Cate	Fault Category:			lo DQA:		Date:			
Resolution:					QA: N/C Closed: Date:						
NCR:			WORK ORDI	ER NON-CONFOR	RMANCE	(NCR)					
DATE	STEP	Description of NC	Corrective Action		Section B			tion	Approval	Approval	
DATE	SILF	Section A	Initial Action Description Sign 8	Sign & Date	Section C		Chief Eng	QC Inspector			
	-										
	, ,									- 12	
		=									
	10									gia.	
										40-14	
			2					1			